DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 99.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-016568
Date Inspected: 04-Sep-2010

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC)

OSM Arrival Time: 700
OSM Departure Time: 1900
Location: Shanghai, China

CWI Name: N/A

Inspected CWI report:	☐ Yes	☐ No	☑ N/A	**CWI Present:**	☐ Yes	☑ No	
Electrode to specification:	☐ Yes	☐ No	☑ N/A	**Rod Oven in Use:**	☐ Yes	☐ No	☑ N/A
Qualified Welders:	☐ Yes	☐ No	☑ N/A	**Weld Procedures Followed:**	☐ Yes	☐ No	☑ N/A
Approved Drawings:	☐ Yes	☐ No	☑ N/A	**Verified Joint Fit-up:**	☐ Yes	☐ No	☑ N/A
				Approved WPS:	☐ Yes	☐ No	☑ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: OBG Trial Assembly

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. S. Manjunath Math was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

Orthotropic Box Girder (OBG) at Trial Assembly Areas

Incident Report generated at Segment 10AE

This Quality Assurance (QA) Inspector wrote an Incident Report for out of flatness issue which was visually observed at Bottom Panel for Segment 10AE at Panel Point (PP) 88 and between PP 85.25 to PP 86 at E4 location. Please reference the Incident Report # 04-0120F4_TL-15_B278_09-04-10_10AE_Out_of_Flatness_Bottom Panel_PP88 and PP85.25 to PP 86 dated September 04, 2010 for further detail.

Please reference the pictures attached for more comprehensive details

Segment 9AW

This QA Inspector performed Dimension Control Inspection for the Segment 9AW at the following locations:

The reentrant corner at Floor Beam vertical flange radius were verified and measured at Panel Points (PP) 72 and

PP 73 at the Counter Weight side (CB) and Cross Beam(CB) side, east and west side of Floor Beam. The QA Inspector measured the radius of reentrant corner using a pre-cut 25mm and 50mm template.

The measurements were recorded in the Dimension Control Plan (DCP) on a separate form and submitted to the Lead Inspector and Engineer for review and disposition.

Segment 9BW

This QA Inspector performed Dimension Control Inspection for the Segment 9BW at the following locations:

The reentrant corner at Floor Beam vertical flange radius were verified and measured at Panel Points (PP) 74, PP 75 and PP 76 at the Counter Weight side (CB) and Cross Beam(CB) side, east and west side of Floor Beam. The QA Inspector measured the radius of reentrant corner using a pre-cut 25mm and 50mm template.

The measurements were recorded in the Dimension Control Plan (DCP) on a separate form and submitted to the Lead Inspector and Engineer for review and disposition.

Segment 9CW

This QA Inspector performed Dimension Control Inspection for the Segment 9CW at the following locations:

The reentrant corner at Floor Beam vertical flange radius were verified and measured at Panel Points (PP) 77, PP 78 and PP 79 at the Counter Weight side (CB) and Cross Beam(CB) side, east and west side of Floor Beam. The QA Inspector measured the radius of reentrant corner using a pre-cut 25mm and 50mm template.

The measurements were recorded in the Dimension Control Plan (DCP) on a separate form and submitted to the Lead Inspector and Engineer for review and disposition.

Segment 9DW

This QA Inspector performed Dimension Control Inspection for the Segment 9DW at the following locations:

The reentrant corner at Floor Beam vertical flange radius were verified and measured at Panel Points (PP) 80, PP 81 and PP 82 at the Counter Weight side (CB) and Cross Beam(CB) side, east and west side of Floor Beam. The QA Inspector measured the radius of reentrant corner using a pre-cut 25mm and 50mm template.

The measurements were recorded in the Dimension Control Plan (DCP) on a separate form and submitted to the Lead Inspector and Engineer for review and disposition.

Segment 9EW

This QA Inspector performed Dimension Control Inspection for the Segment 9CW at the following locations:

The reentrant corner at Floor Beam vertical flange radius were verified and measured at Panel Points (PP) 83, PP

84 and PP 85 at the Counter Weight side (CB) and Cross Beam(CB) side, east and west side of Floor Beam. The QA Inspector measured the radius of reentrant corner using a pre-cut 25mm and 50mm template.

The measurements were recorded in the Dimension Control Plan (DCP) on a separate form and submitted to the Lead Inspector and Engineer for review and disposition.

Cross Beam (CB) 12

This QA Inspector performed Dimension Control Inspection for measuring offset for the Cross Beam (CB) 12 stiffeners to Segment 9DE and Segment 9DW FL3 stiffeners and majority of inspection was performed on August 20, 2010 and as on date gap measurements was performed between the skin plate of Cross Beam to the Segment 9DE FL3 and Segment 9DW FL3.

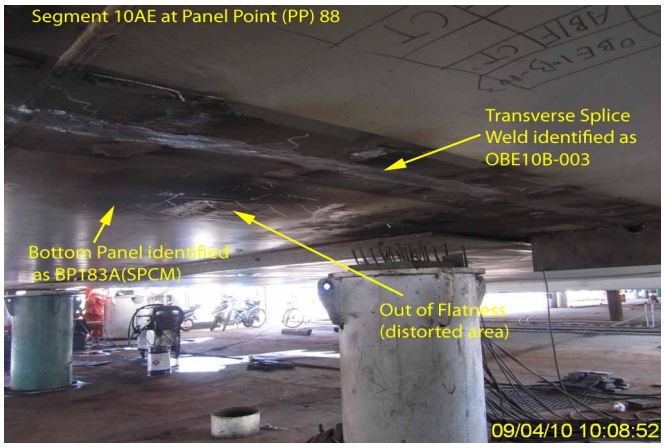
The measurements were recorded in the Dimension Control Plan (DCP) on a separate form and submitted to the Lead Inspector and Engineer for review and disposition.

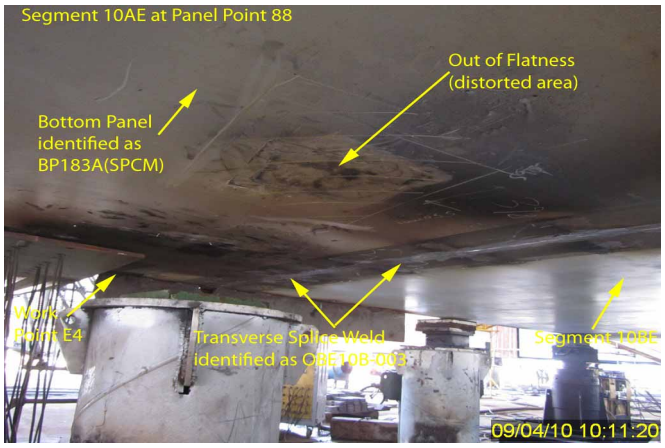
Cross Beam (CB) 11

This QA Inspector performed Dimension Control Inspection for measuring offset for the Cross Beam (CB) 12 stiffeners to Segment 9BE and Segment 9BW FL3 stiffeners and majority of inspection was performed on August 17, 2010 and as on date gap measurements was performed between the skin plate of Cross Beam to the Segment 9BE FL3 and Segment 9BW FL3.

The measurements were recorded in the Dimension Control Plan (DCP) on a separate form and submitted to the Lead Inspector and Engineer for review and disposition.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.





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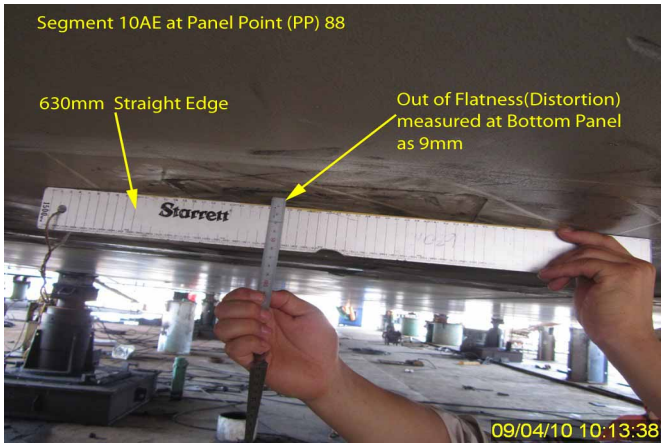

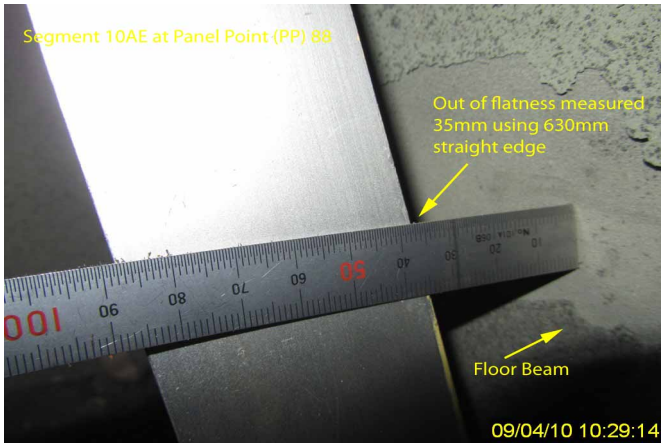

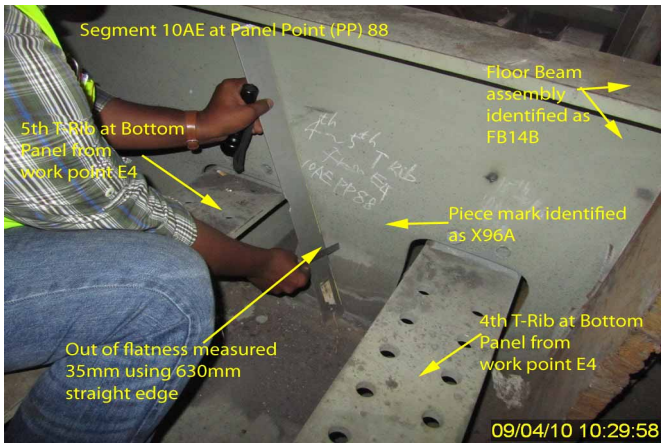

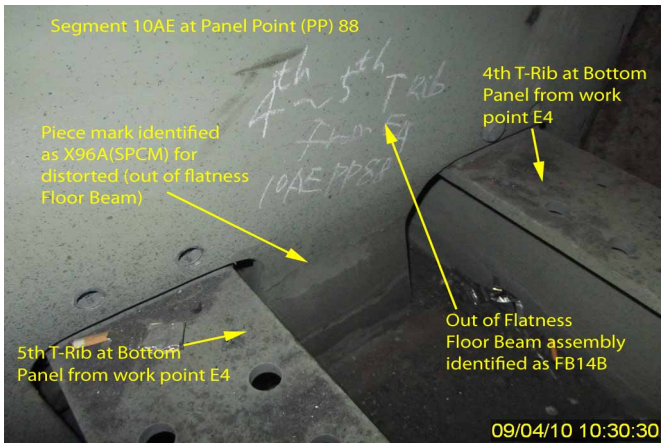

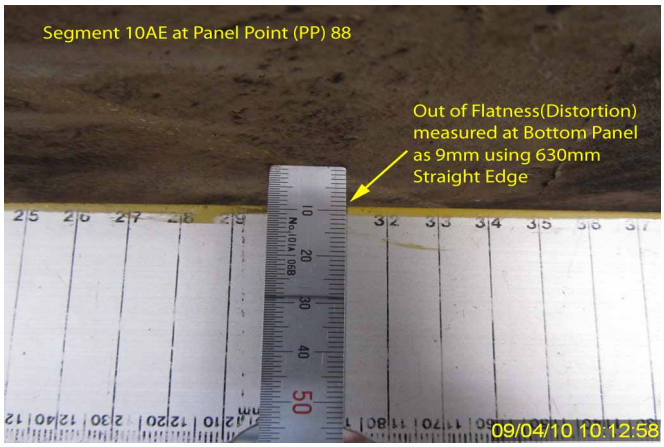

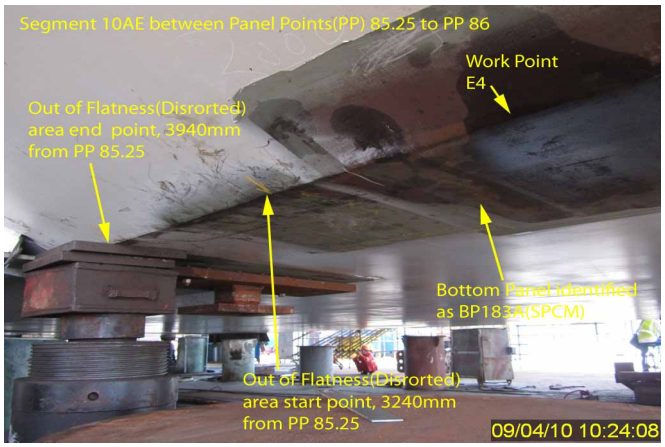

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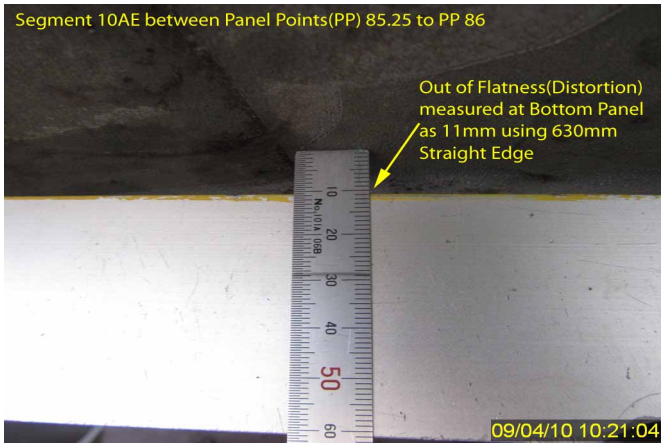

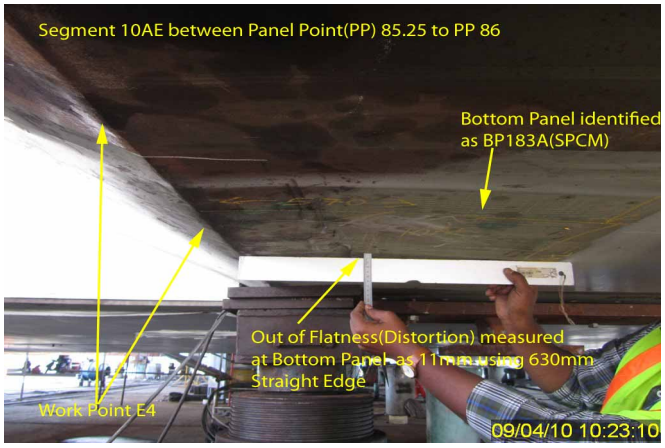

Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Math,Manjunath	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer